

4130 112 W.083

Split 1/2

RUSH SW

Work Order ID 153684 - 2

153684

Page 1

Thursday, November 24, 2016 9:58:19 AM

Item ID: 647.7710

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut Tube

Start Date: 11/25/2016 Start Qty: 12.00

12

9 J.C.B.

Cust Item ID:

Required Date: 12/5/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: VS

Date: NOV 24 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.7700

A2

)

0.00

110*

Mill Conv

Memo

0.00

Conventional Milling Machine

1- CUT AS PER DWG
2- Mill end of tube as per dwg
3- DEBURR AS PER DWG

DAS
32
9-89

16-11-28

)

QC6- Inspect dimensions to drawing

0.00

120*

C

Memo

0.00

Quality Control

DAS
38
9-89

NOV 28 2016

)

Identify as per dwg & Stock Location: W1002

0.00

130*

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

9 NOV 29 2016

DAS
6
9-89

Work Order ID 153684***153684***

Page 2

Thursday, November 24, 2016 9:58:19 AM

Item ID: 647.7710 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Tube
Start Date: 11/25/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 12/5/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

NOV 29 2016

16/11/29 JG

Picklist Print

Thursday, November 24, 2016 9:58:24 AM

Page 1

Work Order ID: 153684

153684

Parent Item: 647.7710

647 7710

Parent Item Name: Strut Tube

Start Date: 11/25/2016

Required Date: 12/5/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 12.11.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.500W.083		Purchased			No	110	f	7.8330	0.82	10.35789			

M4130NT0 500W 083

4130 RD tube .500 x .083W

Location

Loc Qty

Loc Code

MAT032

7.833

M135325

7.833

7,832 ±

11-11-26

DART AEROSPACE LTD	Work Order:	153687
Description: Strut Tube	Part Number:	647.7710
Inspection Dwg: 647.7700 Rev: A2		Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	32	Checked by:	DAS 38	QC Inspector:	
Date:	16-11-20	Date:	9-89 16-11-28	Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

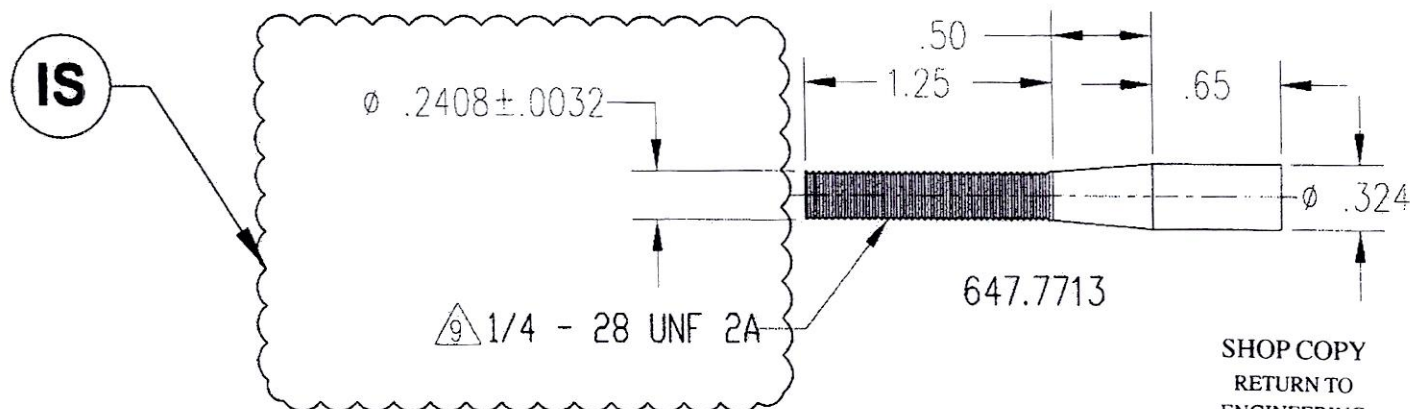
Rev	Date	Change	Revised by	Approved
A	15.11.19	New Issue	KJ	
B	16.05.27	Dwg Rev updated	KJ	



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO. 05397		SHEET 1 OF 1	
DWG NO. 647.7700	REV: A	PREPARED BY T. CROSS	DATE: 05/02/16
DWG TITLE: STRUT ASSY			EFFECT ON DWG ☐ INC. ☒ UNINC.
APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER
REASON: REVISED DIMENSION			ECR: 16-028
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE			ACTION LIST: 1.

SHEET 2, ZONE D4 IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153684

V-152
16/4/24

DOCUMENTS EFFECTED:	CHANGE CATEGORY	DER REVIEW REQUIRED
☐ PATTERN ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM	☐ MAJOR ☒ MINOR	☐ YES ☒ NO



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05110

SHEET 1 OF 1

DWG NO. 647.7700

REV: A

PREPARED
BY

A. QUAN

DATE: 08/21/15

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD
R-REVISE
C-CREATE
D-DELETE

REASON: REVISED FINISH CALLOUT AS PER ECR 15-209

SHEET 1, NOTES IS:

ACTION: UPDATE MO & WO

NOTES:

- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW QQ-P-416F CLASS I TYPE II
- 9 MASK THREAD PRIOR TO FINISH

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:					
☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM					
CHANGE CATEGORY					
☐ MAJOR ☐ MINOR					
DER REVIEW REQUIRED					
☐ YES ☐ NO					

1. MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
2. MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
3. MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
4. FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MFP-120.
7. WELD IAW MIL-STD-2219, TIG WELD WITH FILLER ROD
8. FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
9. MASK THREAD PRIOR TO FINISH

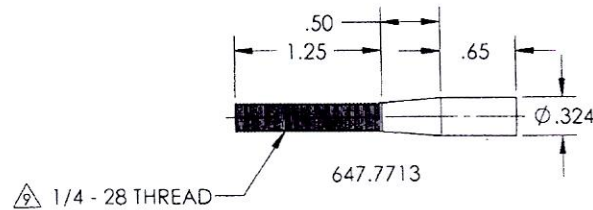
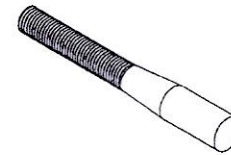
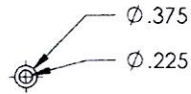
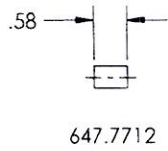
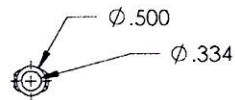
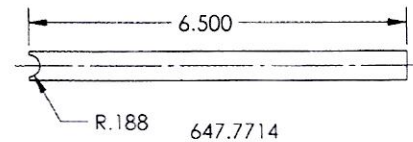
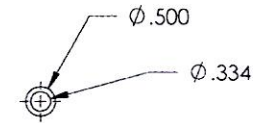
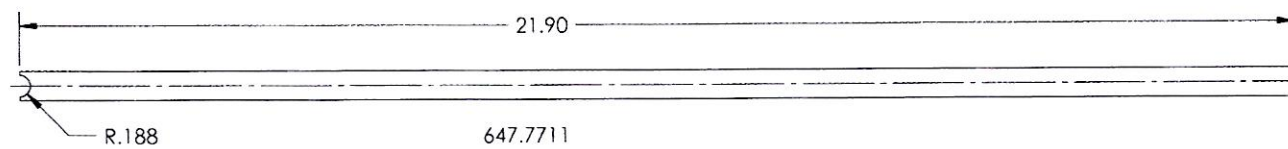
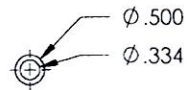
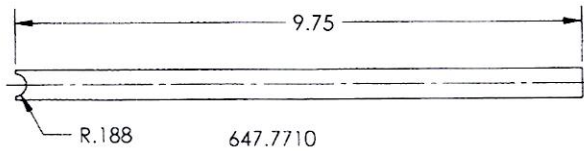
REV SKIPS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION PR2		N/C
N/C	INITIAL RELEASE	12/02/99	P. BRAVO
A	INCORPORATED ECU DATA	11/1/01	P. BRAVO

UNINCORPORATED ECN(S)

05/10, 05397

			5	647.7714	STRUT TUBE	△	
1	1	1	4	647.7713	STRUT THREAD	△	△
1	1	1	3	647.7712	STRUT TUBE	△	
		1	2	647.7711	STRUT TUBE	△	
		1	1	647.7710	STRUT TUBE	△	
△	△	△		647.7703	STRUT ASSY		△ △
	△	△		647.7702	STRUT ASSY		△ △
	△	△		647.7701	STRUT ASSY		△ △
7703	7702	7701	FIND #	PART #	DESCRIPTION	MAT.	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				APICAL INDUSTRIES			
647.7300				2608 TEMPLE HEIGHTS DR. OCEANSIDE CA 92036-3512 (760)724-5300			
646.4000				STRUT ASSY			
				REV A SPECIAL DATE DRAWN BY J. JACKSON CHECKED D. BARBER APPROVED: SIGNED DATE/FAC NO			
				WELD OTHERS SPECIFIED DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED 1 PLACE DECIMALS = .001 2 PLACES = .0005 3 PLACES = .0001			
				SET 1 ASL CODE 2ND NG SCALE NONE 647.7700 SHEET 1 OF 2			

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ORIGINAL DATE (ADD DATE) 1/1/2006 DRAWN BY: J. JACKSON DRAWING APPROVAL: P. BRYAN		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONFIRMED NO. PARTS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED 2 PLACE DECIMALS 1/16 3 PLACE DECIMALS 1/32 4 PLACE DECIMALS 1/64		STRUT ASSY	
SET: 6 DATE: 6/1/16	DWG. NO.: 647.7700	REV.: A	SCALE: NONE
		SHEET 2 OF 2	